

Work Order ID: 79131

January-20-12 1:40:16 PM

79131

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4269-5

Accept

N900040100

Setup Start

NS1

Revision ID: ~~PRELIM~~

Stop

NS2

Item Name: Angle

Start Date: 20/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: M.C.J.

Date: 12/01/20

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4269

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Cut to length as per dwg
2- Drill two holes to make R0.25 @ 2 place as per dwg (use 1/2 unibite)
3- Trace and cut angle as per dwg
4- Deburr

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4269-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Angle
 Start Date: 20/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 03/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130						4	0	11	12/01/25
QC	Memo	0.00				correct			
Quality Control									
140	Identify as per dwg & Stock Location: <u>200</u>	0.00							
140									
Packaging	Memo	0.00							12/1/2012 (4)
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									12/1/30 (J)
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 12/1/10 AUTH 11

RELEASED DATE

SMF
12-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 79131

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Parent Item: D4269-5

D4269-5

Parent Item Name: Angle

Start Date: 20/01/2012

Required Date: 03/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A.750X.750X. 063W		Purchased	No			100	f	23.9330	1.9375	8.157895			

M2024T3A 750X 750X 063W

Angle2024T3511 .750 x .750 x .063w

**

Location

MAT028

103509

116909

Loc Qty

23.933

22.164

1.769

Loc Code

8.2

12/01/24

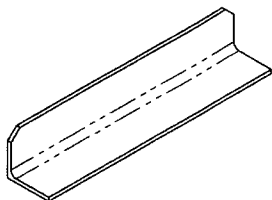
W/O:		WORK ORDER CHANGES					
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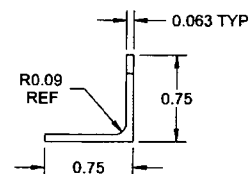
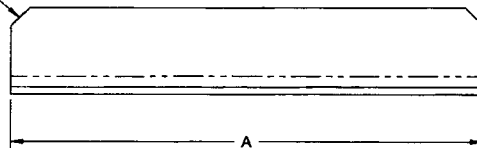
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0.16 x 45°
CHAMFER
2 PL



D4269-X
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	A	WEIGHT
D4269-1	ANGLE	EA20469-33	4.03	0.04
D4269-3	ANGLE	EA20469-30	4.63	0.04

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: SEE TABLE

RELEASED
2011-04-06
WN

REV.	DESCRIPTION	RF	DATE
A	NEW ISSUE		10.11.22
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4269	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
DATE	10.11.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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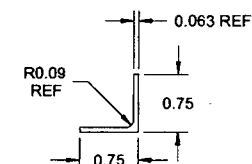
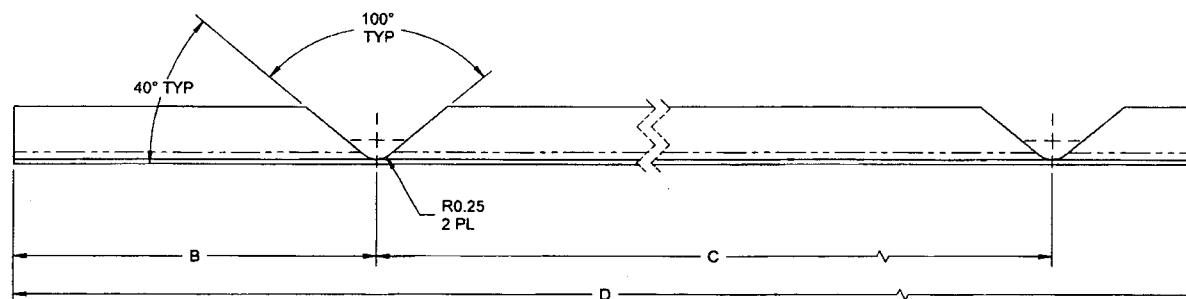
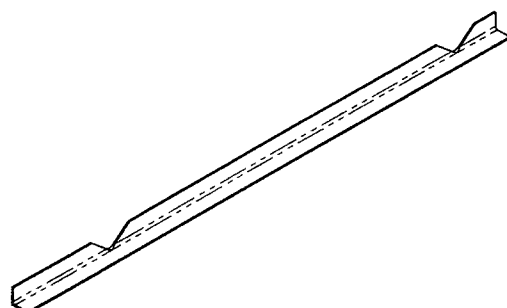
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D4269-Z
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	B	C	D	WEIGHT
D4269-5	ANGLE	EA20469-29	4.66	16.69	23.25	0.21
D4269-7	ANGLE	EA20469-32	2.28	16.5	22.03	0.19

RELEASED
2011-04-06

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- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4269	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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